Work Order ID 87195

87195

July-11-12 10:07:18 AM

Item ID: D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Rear Locker Extender

Start Date: 7/16/12 **Start Qty:** 1.00 *1*

Required Date: 8/24/12 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2273	F
D350-604-041	B

100 0.00

100

DC

Document Control

DOCUMENT CONTROL

DAS 12/4/30

MLS 12/07/30

Memo 0.00

Photocopy bluefile and create labels per PPP D350-604-041

CHG003 for D2273 rev.E (new gelcoat)

CHG004 for D2273 rev.F (new primer)

110 0.00

110

Purchasing

Purchasing

PURCHASING

Memo 0.00

Issue P/O: 17520

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B_____

4 x 2600-LW Retaining washers - Ship to Delastek B_____

12.07.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Rear Locker Extender

Start Date: 7/16/12 **Start Qty:** 1.00 *1*
Required Date: 8/24/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120	Packaging						12/7/23		
Packaging	**Memo**	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.								
130	QC5- Inspect part completeness to step on W/O	0.00							
130						1	0	12/07/30	DAS 29
QC	**Memo**	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140		0.00							
140									
Small Fab	**Memo**	0.00							
Small Fab	INSTALL DECALS AS PER DWG								

SAND & BUFF FLANGE SURFACE
D M/12.07.26

DH 12/07/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D350-604-041 **Accept** *N900040100* **Setup Start** *NS1*
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Item Name: Rear Locker Extender

Start Date: 7/16/12 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 8/24/12 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150		5 12/4/30							
QC	**Memo**	0.00							
Quality Control									
160		0.00							
160	Packaging							12/7/30	
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D350-604-041 Location:_____ PPP Rev:_____								
170	QC21- Final Inspection - Work Order Release	0.00							
170							MCJ	12/07/30	
QC	**Memo**	0.00							
Quality Control									

MCJ 12/07/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:07:17 AM

Work Order ID: 87195

Parent Item: D350-604-041 **Start Date:** 7/16/12 **Required Date:** 8/24/12

Parent Item Name: Rear Locker Extender **Start Qty:** 1.00 **Required Qty:** 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R 12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No			110	Each	199.0000	4	4			
				Location		**Loc Qty**		**Loc Code**					
				ST380		199							
					120077	8							
					121556	4							
					122317	42							
					122335	145							
2600-LW Camloc Retaining Washer		Purchased	No			110	Each	319.0000	4	4			
				Location		**Loc Qty**		**Loc Code**					
				ST380		316							
					121524	116							
					122317	200							
				ST381		1							
					121287	1							
				ST398		2							
					120648	2							
D2268 Decal		Manufactured	No			140	Each	31.0000	1	1			
				Location		**Loc Qty**		**Loc Code**					
				ST007		20							
					80010	20							
				ST009		11							
					69592	2							
					78908	9							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 87195

Parent Item: D350-604-041 **Start Date:** 7/16/12 **Required Date:** 8/24/12

Parent Item Name: Rear Locker Extender **Start Qty:** 1.00 **Required Qty:** 1.00

D2269 Decal	Manufactured	No		Each	25.0000	1

Location	Loc Qty	Loc Code	
ST007	20		
80011	20		
ST009	5		
78920	5		1

D350-604-041P Rear Locker Extender	Purchased	No	110	Each	0.0000	1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

****Certificate of Conformity****

Customer:
Dart Aerospace

Purchase Order #:	Packing Slip #:	Part #:	Serial #:
no PO provided		DKC134-0081	Prototype

Description:	Quantity:
Stealth spec 2 ply flange locker	1

Certification:

We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

APPROVAL:	DATE:
Signature: [signature]	7/20/2012
Title: President	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Stealth Composites Inc.

Process Data Sheet

Date:	07/16/12	Part Name:	Stealth spec extended locker
Client:	DART	Part Number:	prototype
Job:	Prototype	Revision:	n/a
Comments:	Stealth spec locker 2 ply flange	Material:	fiberglass/FR polyester resin
		Quantity	1

Resin:	Hetron FR 650 T-20	Batch:	0001291211
Gelcoat:	G730AA1100	Batch:	G31
Catalyst	Cadox M-50A	Batch:	12041F0701
Fiber:	1.5 oz random fiberglass mat		

	Operation	Date	Initial
Setup:	n/a		
Mold Prep:	clean with dry cloth	7/17	JAD
Material prep:	Cut fiberglass to fit mold	7/17	JAD
Mix gelcoat:	Catalyze gelcoat @1.5% Cadox	7/18	JAD
Apply gelcoat:	Spray mixed gelcoat onto mold	7/18	JAD
Mix resin:	Catalyze resin @1.5% Cadox	7/18	JAD
Apply Fibers:	apply cut fiberglass mat to mold	7/18	JAD
Apply Resin:	Saturate fibers with resin	7/18	JAD
Cure time:	24 hrs		
Demold:	remove locker from mold	7/19	JAD
Trim:	cut and sand flange per drawing	7/19	JAD
Drill holes:	4 holes drilled per drawing	7/19	JAD

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
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General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
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- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

DART aerospace
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17520

Purchase Order Date 7/23/12
PO Print Date 7/23/12

Order From : VU-STE002

STEALTH COMPOSITIES INC.
3 NORTH COLUMBUS BLVD.
PHILADELPHIA, PHILADELPHIA PA 19106
USA

Contact Name		**Buyer**	Linda Lacelle
Vendor Phone	215-919-7584	**Requisition Nbr**	
Vendor Fax	215-689-4979	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 10
		Currency	USD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference / Revision ID / Vendor Part Number	Description / Mfg ID	Req Date / Taxable	Req Qty / Unit of Measure	Ship Method	Unit Price	Extended Price
1	D350-604-041P	Rear Locker Extender	7/23/12 Yes	1.00 Each		$750.0000	$750.00

1/c 12/7/PO3

PO Total: **$750.00**

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required - YES NO

Change Nbr: 1 **Change Date:** 7/23/12

DART AEROSPACE LTD	Work Order:	67195
Description: Rear Idler Brackets	Part Number:	D2273
Inspection Dwg: D2273 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

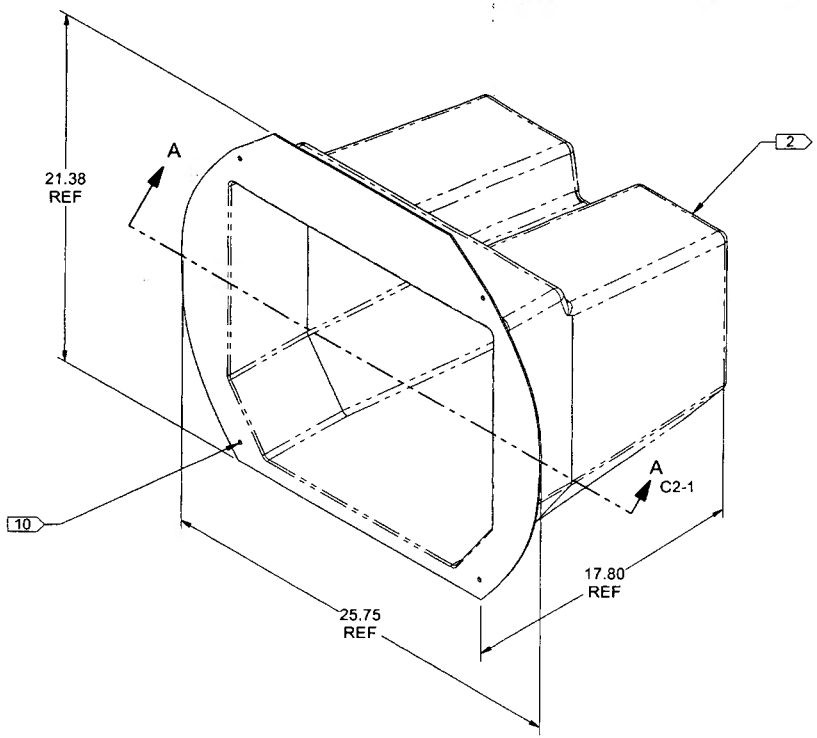
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.38" (Ref)	±.030	21.375	✓		T-M	A1425
17.80" (Ref)	±.030	17.750		—	T-M	A1425
25.75" (Ref)	±.030	25.75	—		T-M	A1425

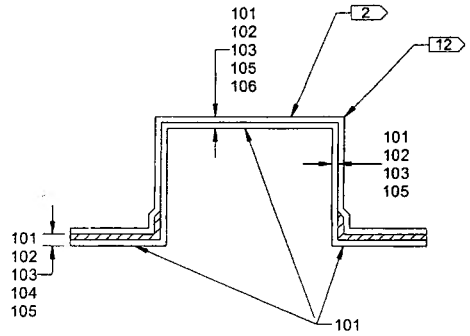
Measured by:	
Date:	

Audited by:	
Date:	

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	





SECTION A-A
C4-1

RELEASED
2012 -03- 29

NOTES:
1) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS
18 oz = 18.0 oz ROVING "E" GLASS
2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/LE 1175-S (F)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 7.75 lbs
8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACCUM
10) TRIM & DRILL PER DT8020. OPEN HOLES TO Ø0.257 (4 PLACES)
11) CONSTRUCTION:
101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020
102-9 oz ALL OVER
103-18 oz ALL OVER
104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES
105-9 oz ALL OVER
106-PEEL PLY
12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

D2273 REAR LOCKER EXTENDER

REV.	DESCRIPTION	BY	DATE
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27

DESIGN	JB	**DART AEROSPACE LTD**
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2273 REV. F
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE 350 REAR LOCKER EXTENDER SCALE NTS
DE APPR.		
DATE	12.02.27	

Ashland launches Hetron™ FR 650T-20, a new high-strength fire retardant resin

02/10/2012

DUBLIN, Ohio – In response to the need for a versatile, high-performance fire retardant polyester resin, Ashland Performance Materials, a commercial unit of Ashland Inc. (NYSE: ASH), has developed Hetron FR 650T-20 resin. This new high-strength resin is a low-viscosity, promoted, thixotropic polyester with exceptional fire retardant properties.

"Ashland recognized the need to move away from some more volatile fire retardant ingredients and developed a new cost-effective chemistry that will better serve the needs of the market," said Thom Johnson, Fire Retardant Composite industry manager, Ashland Performance Materials. He also added that "properly fabricated laminates made with Hetron FR 650T-20 resin can achieve Class I flame spread rating in ASTM E-84 testing without the use of antimony synergists."

Hetron FR 650T-20 is ideally suited for hand lay-up, spray-up and filament-winding applications. It exhibits excellent wet out properties and low drainage when applied to vertical surfaces. Its flame retardant properties make it especially attractive for use in mass transit, architectural, electrical and ducting applications.

To learn more about the new Hetron FR 650T-20, please visit Ashland at booth No. 1153 at the upcoming Composites 2012 show in Las Vegas, Nev., Feb. 21-23, 2012. Or, contact your Ashland representative directly to learn more about the product.

Ashland Performance Materials is the global leader in unsaturated polyester resins and vinyl ester resins. In addition, it provides customers with leading technologies in gelcoats, pressure-sensitive and structural adhesives, coatings and elastomers.

In more than 100 countries, the people of Ashland Inc. (NYSE: ASH) provide the specialty chemicals, technologies and insights to help customers create new and improved products for today and sustainable solutions for tomorrow. Our chemistry is at work every day in a wide variety of markets and applications, including architectural coatings, automotive, construction, energy, food and beverage, personal care, pharmaceutical, tissue and towel, and water treatment. Visit www.ashland.com to see the innovations we offer through our four commercial units—Ashland Specialty Ingredients, Ashland Water Technologies, Ashland Performance Materials and Ashland Consumer Markets.

– 0 –

FOR FURTHER INFORMATION:
Media Relations
Karen Barnish
+1 614-790-4025
kbarnish@ashland.com

AOC®
World Leader in Resin Technology

Vibrin® G730AA Polyester Gelcoat

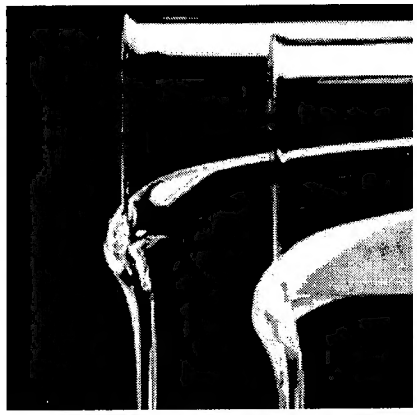
Product Information

Vibrin® Polyester Gelcoat for FireRetardant Spray Applications

TYPICAL LIQUID RESIN PROPERTIES* (1) see back page

	Typical Range
Viscosity @ 77°F/25°C, RVF Brookfield Spindle #4 @ 20 RPM, cps.	4500 - 6000
Thix ratio (2:20 RPM)	6.5 - 8.5
Gel Time @ 77°F/25°C (1.5% MEKP), minutes	8 - 11
Exotherm Time, minutes	5 - 15
Exotherm Temperature, °C	160 - 190
HAP Content, %	35 - 45

*Typical properties are not to be construed as specifications.



DESCRIPTION

AOC's Vibrin®G730AA is a fully promoted, thixotropic, fire retardant, polyester gelcoat for spray applications. Consult the Colour Selection Guide for examples of colours available.

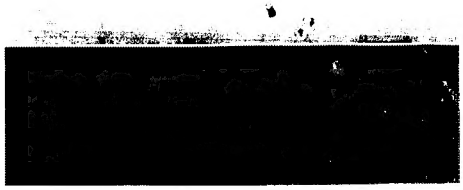
FEATURES

- Formulated to surpass UL94 V-0 Flame Testing
- High halogen content
- Good processability
- Fast cure

APPLICATIONS

AOC's Vibrin® G730AA is designed to be used in fire retardant applications. It must be used in conjunction with a suitable fire retardant laminating resin in order for the entire composite to give fire retardant properties. This product has moderate weathering characteristics and is not suited for applications where UV resistance is required.

Vibrin® G730AA Polyester Gelcoat



APPLICATION GUIDELINES

A. All AOC thixotropic polyester gelcoats should be mixed well prior to use.

B. MEKP levels should be kept between 1.0% and 2.5%.

C. Gelcoat should not be applied at temperatures below 64°F/18°C.

D. Recommend spraying 3 passes at 5-8 mils allowing a short flash time between passes.

MINIMUM STORAGE STABILITY

AOC's G730AA gelcoat is stable for three months from date of production when stored away from sunlight at no more than 77°F/25°C. Storage at elevated temperatures will reduce shelf life. After extended storage, some drift may occur in gel time or viscosity.

SAFETY

See appropriate Material Safety Data Sheet for guidelines.

ISO 9002 CERTIFIED

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9002 standards. This certification recognizes that each AOC facility has an internationally accepted model in place for managing and assuring quality. We follow the practices set forth in this model to add value to the resins we make for our customers.

FOOTNOTES

(1)

Gel times shown are typical but may be affected by catalyst type and level, and by gelcoat, mold and shop temperature. Variations in curing characteristics can be expected between different lots of catalysts and at extremely high humidities. It is recommended that the fabricator check the curing characteristics of a small quantity of gelcoat under actual operating conditions prior to use.

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Pub. No. G-AOC-G730AA

Effective Date: Setpember, 2003